

# Work Order ID 110116

December-17-13 9:15:28 AM

**\*110116\***

Page 1

Item ID: D3914-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Long Basket Lid Assembly (350)  
 Start Date: 12/17/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	C
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 4123823 0.00  
 Large Fab  
**\*100\***  
 Large Fab  
 Large Fab  
 Memo 0.00  
 1- assemble ribs , weld as per dwg D3914 using DT9607A  
 2- weld hinge (3) and Mounting brackets as per dwg D3914  
 \*\*\*Visual inspect before welding mesh\*\*\*  
 3- tack weld mesh on basket as per dwg D3914  
 \*\*\*Cut out mesh where label plate goes in center off basket lid as per dwg  
 D4020-5. Make sure to place mesh correctly on lid, check with label plate before  
 tacking mesh\*\*\*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
**\*110\***  
 QC Memo 0.00  
 Quality Control

1x DAS  
43  
9-89 14-01-15

① 14017 DAS  
9  
9-89



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Page 2

Item ID: D3914-041 Accept **\*N19000040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Long Basket Lid Assembly (350)  
Start Date: 12/17/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 12/17/13 Req'd Qty: 1.00 **\*1\*** Customer:  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
<b>*130*</b>									
Powdercoat	Memo	0.00							DAS 34 9-89
Powder Coating	*** mask sides of hinge prior to powdercoat*** Start Time: <u>8:25</u> Oven Temperature: <u>320°</u> Finish Time: <u>9:05</u>								
140	Wing Walk as per dwg QSI005 4.4 Batch _____	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***								

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**\*110116\***

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Item ID: D3914-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Long Basket Lid Assembly (350)

Start Date: 12/17/13

Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/17/13

Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

0.00

Quality Control

1 / 14-01-20

160

Identify as per dwg & Stock Location: W10

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

D 4030-041/B110164

1K 6 92 14-01-20

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

14-01-22

14-01-21

# Picklist Print

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Page 1

Work Order ID: 110116

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM  
 IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D3914-1 Rib		Manufactured	No			100	Each	8.0000	2	2	DAS 43 8-89	14.01.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		8							
				105977		8			2x				
✓ D3914-7 Rib		Manufactured	No			100	Each	6.0000	2	2	DAS 43 8-89	14.01.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		6							
				107271		6			2x				
✓ D4018-5 Rib		Manufactured	No			100	Each	24.0000	9	9	DAS 43 8-89	14.01.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		24							
				100347		3							
				104988		18			9x				
				106726		3							
✓ D4035-043 Lid Rib Assembly, Aft (350 Basket)		Manufactured	No			100	Each	2.0000	2	2	DAS 43 8-89	14.01.09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		2							
				107509		1							
				108589		1							

# Picklist Print

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Work Order ID: 110116

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

\* D2581 Manufactured No 100 Each 264.0000  
Mounting Bracket

Location	Loc Qty	Loc Code
WA004	264	
102265	94	
103683	98	
105886	48	
107768	24	

<sup>2</sup> B107768 → 2x

DAS  
43 14.01.09  
9-89

✓ D4016-3 Manufactured No 100 Each 43.0000  
Hinge Half, Lid

Location	Loc Qty	Loc Code
WA004	43	
103029	23	
106882	20	

3 3 DAS  
43 14.01.09  
9-89

✓ D4020-5 Manufactured No 100 Each 1.0000  
Mesh (350 Basket Long, Lid)

Location	Loc Qty	Loc Code
WA004	1	
107300	1	

<sup>1</sup> B110222 <sup>1</sup> DAS  
43 14.01.09  
9-89

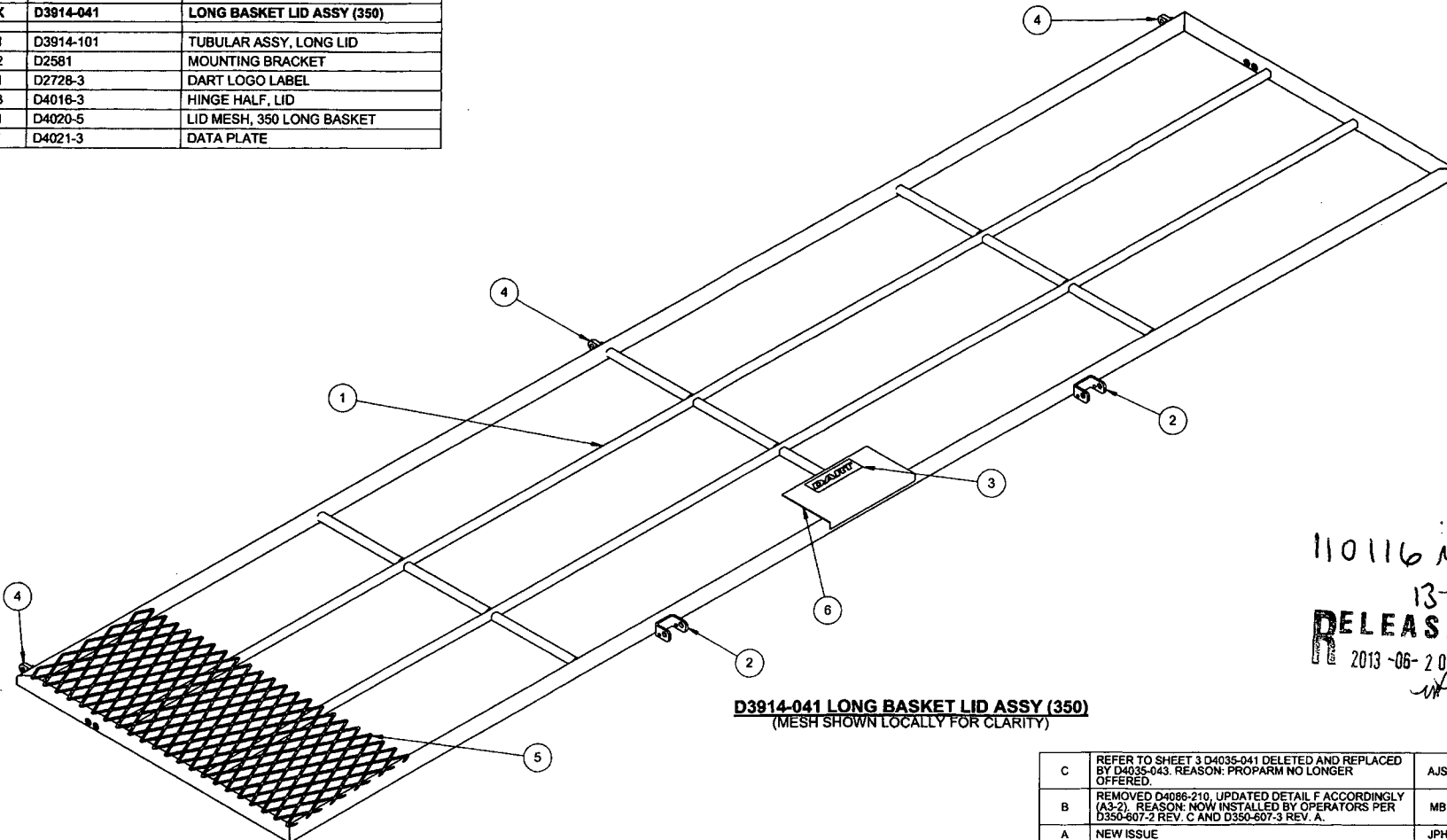
✓ D4021-3 Manufactured No 100 Each 27.0000  
Data Plate

Location	Loc Qty	Loc Code
WA004	27	
101346	27	

1 1 DAS  
43 14.01.09  
9-89

1x

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
5	1	D4020-5	LID MESH, 350 LONG BASKET
6	1	D4021-3	DATA PLATE

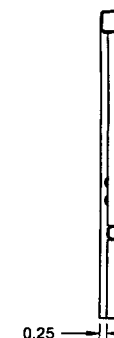


**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

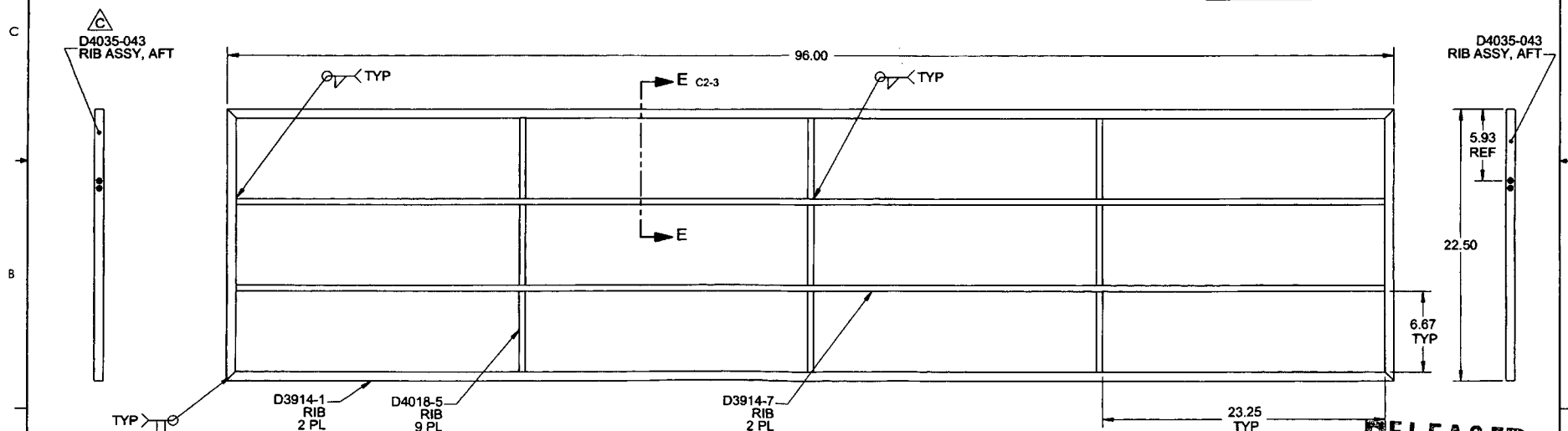
110116 MJS  
13-12-09  
**RELEASED**  
2013-06-20  
WJD

C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROPARM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	DS	D3914	SHEET 1 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET LID ASSY (350)	NTS
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

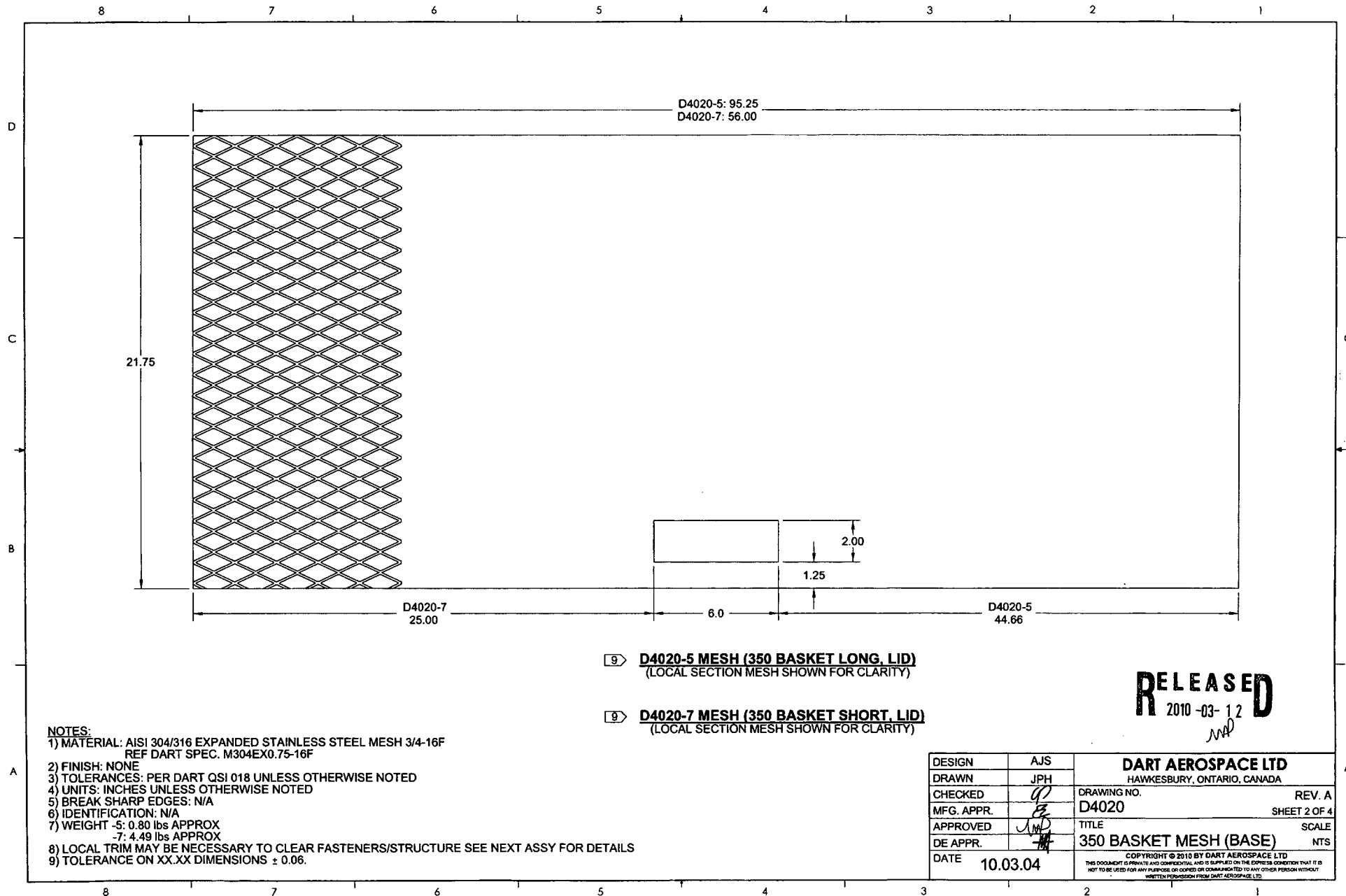
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3914-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	SS	D3914	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	SH	LONG BASKET LID ASSY (350)	NTS
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RELEASED  
2013-06-20





9) **D4020-5 MESH (350 BASKET LONG, LID)**  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

9) **D4020-7 MESH (350 BASKET SHORT, LID)**  
(LOCAL SECTION MESH SHOWN FOR CLARITY)

**NOTES:**

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F  
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -5: 0.80 lbs APPROX  
-7: 4.49 lbs APPROX
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS  $\pm 0.06$ .

**RELEASED**  
2010-03-12  
MD

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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